

Date: Wednesday, 02/05/2007 9:42:50 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INLET SCOOP
Job Number	: 32133 -2	Part Number	: D34789
Estimate Number	: 12421	Drawing Number	: D3478 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 02/05/2007 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 09/05/2007
Previous Run	: 27542	Qty:	10 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev: A New Issue 06-01-31 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 3682 For D3478-9S

Spin as per Dwg D3478

Possible Supplier: SIEG

Material release note is required

U 7-05-02

2.0	D34789S	INLET SCOOP, SPINNING DETAIL
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 scoop outlet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

Pe 7/5/4 10

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

18070504 (9)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scribe line at .180" Below center line of part

2-Rough Cut Part on Band Saw Leaving some Material.

18070504 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/05/2007 9:42:50 AM
User: Linda Labelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET SCOOP

Job Number: 32133 -2

Part Number: D34789

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Using DT8842 Angle Block, Sand Part on Disk Sander to Scribed line.

4-Deburr.

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FF 07-05-07 9

07/05/08 (9)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/08 (9)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/08 (9)

Job Completion



07/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

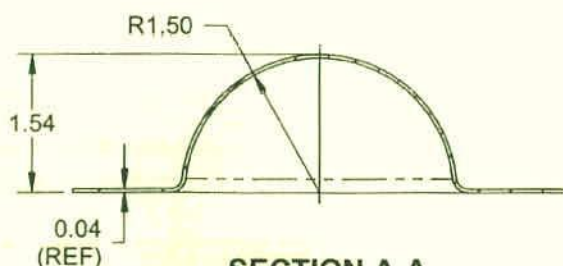
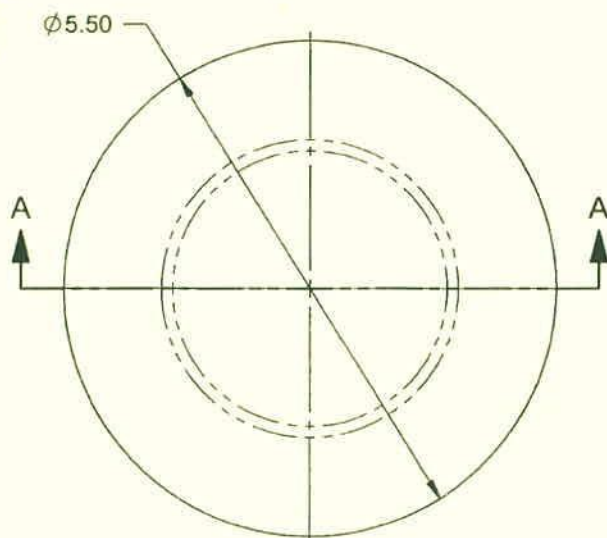
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

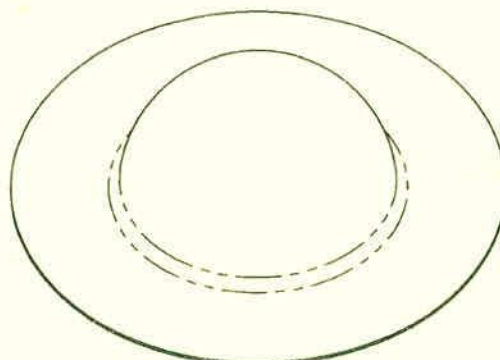


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3478	REV. B SHEET 6 OF 7
DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16



SECTION A-A



u/032133

D3478-9S AIR INLET SCOOP, SPINNING DETAIL

NOTES:

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4
OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

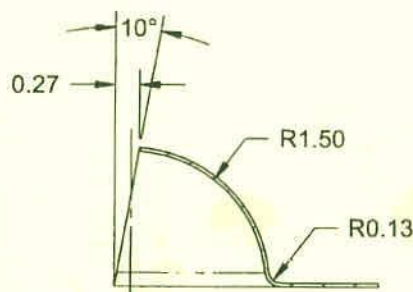
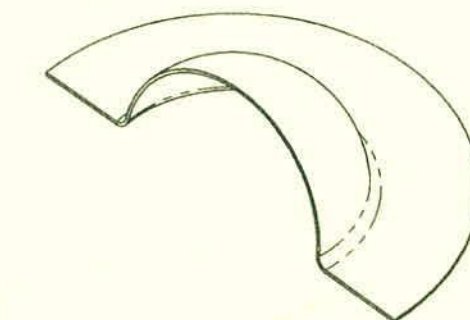
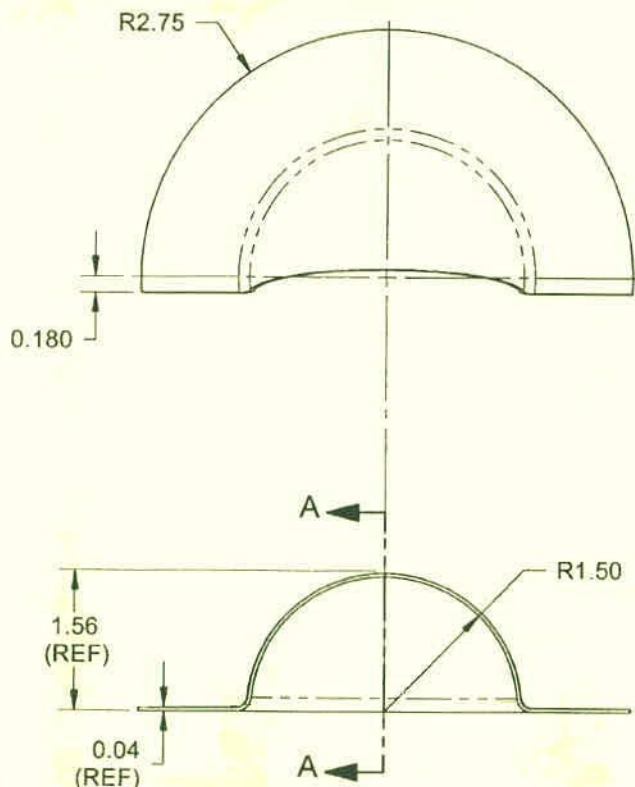
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3478	REV. B
DATE 06.05.16		TITLE AIR INLET ADAPTER	SHEET 7 OF 7 SCALE 1:2

RELEASED
06.05.16**SECTION A-A****D3478-9 INLET SCOOP****NOTES:**

- 1) MATERIAL: MAKE FROM D3478-9S
- 2) IDENTIFY WITH DART P/N D3478-9 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: May 3/01

Customer: Dart Aerospace

Packing Slip: 31197

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By.
D347895 .	10	2024-O	—	—	Ø

Notes:

good.

Material Certification Attached: ✓

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certifi-
cate has been inspected with, and has been found to meet, the
applicable requirements described therein, including any specifications forming a part of the description and that samples
representative of the material meet the composition limits and had the mechanical properties shown on the face of this sheet
Per:

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

205131

Ship Date

2003-01-10

P.O. No./Govt Contract No.

8G6265

9050

B.L. No.

24546

Invoice No.

56912

Customer

CLB-WALLINGFORD

Alcoa No. Item

DS-56734-1

Page 2

CQR: 0137587.1 -Specification Limits (cont.)

Temp Dir	UTS KSI	TYS KSI	EL4D PCT
T62 Long Transv.	Max		
	Min	60.0	47.0 5

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 2024	Max	.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15
	Min			3.8	.30	1.2					REMAIN

Chemical Composition	SI+PE	CU	MN	MG	V	ZN	TI	Other Each	Aluminum
LINER	Max	.70	.10	.05	.05	.10	.03	.03	
Alloy 1230	Min								99.30

Lot: 533531 -Mechanical, Physical, Metallography, Quantometer Results

Temp Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
0 Long Transv.	2	Max	23.4	11.5
		Min	23.4	11.4

Temp Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T42 Long Transv.	2	Max	60.8	37.6
		Min	60.5	37.5

Temp Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T42P Long Transv.	2	Max	52.5	38.4
		Min	52.4	38.2

Temp Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T62 Long Transv.	2	Max	61.8	49.4
		Min	61.6	48.9

CERTIFIED INSPECTION REPORT

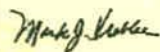
Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

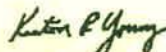
Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per



Mark J. Vrabec
Director of Manufacturing Davenport Works



Kanton P. Young
Quality Assurance Manager

205131

Ship Date

2003-01-10

P.O. No./Govt Contract No.

8G5265

9050

B.L. No.

24546

Invoice No.

56912

Customer

C&B-WALLINGFORD

Alcoa No. Item

DS-56734-1

Page 3

Lot: 533531 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
 Cast Number Chemical SI FE CU MN MG CR ZN TI
 H9532015 Actuals .07 .17 4.6 .64 1.6 .01 .10 .03

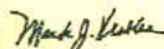
CERTIFIED INSPECTION REPORT

Alcoa Inc.

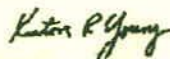
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Mark J. Vreblec
Director of Manufacturing Davenport Works



Kanton P. Young
Quality Assurance Manager

205131
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9050
B.L. No.

24546

Invoice No.

56912

Alcoa No. Item

DS-56734-1

Page 1

P.O. No./Govt Contract No.

8G6265

Customer

C&B-WALLINGFORD

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DRIVE
WALLINGFORD, CT 06492

Item Description

.040 IN TH (+.0000 -.003) X 48 IN W X 144
IN LN (N) A/T ALCLAD 2024-O FLAT SHEET MILL FINISH (PART 752603-
1) RAWMA 02-182-030, PER(EXC GA TOL) AMS-QQ-A-
250/5 REV A & EXCEPT MARKING
ASTMB209 REV 02 & EXCEPT MARKING AMS4040 REV M
((MARKED)) INTERLEAVED MAX GROSS
SKID WGT: 2400 LB QUAN TOL +/-30 %
CQR 0137587 REV 01 QRR 000879 CUST REQ 02-12-
15 *** W/E 02-12-21 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	639714	533531	2035	77	PC	
2	639810	533531	795	30	PC	
3	639812	533531	2011	77	PC	
4	639813	533531	2115	81	PC	
5	639814	533531	2039	77	PC	
			8995.	342		

Notes For CQR: 0137587.1

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/5 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/5F, AMENDMENT 2.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/5F, AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/5.

CQR: 0137587.1 -Specification Limits

Temp	Dir	UTS	TYS	ELAD
0	Long Transv.	KSI	KSI	PCT
	Max	30.0	14.0	
	Min			12
		UTS	TYS	ELAD
742	Long Transv.	KSI	KSI	PCT
	Max			
	Min	57.0	34.0	15
		UTS	TYS	ELAD
742P	Long Transv.	KSI	KSI	PCT
	Max			
	Min	57.0	34.0	15

C & B
Q.C. APPROVED
17-8

SIKORSKY

